

Work Order ID 64335

Thursday, December 02, 2010 1:39:17 PM



Page 1

Item ID: D4106-5	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Spacer, Sill Doulber				
Start Date: 12/2/2010	Start Qty: 8.00		Cust Item ID:	
Required Date: 12/15/2010	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>RL</u>	Date: <u>10-12-3</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4106	A								

100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
KyDEX									
	Memo								
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
QC		0.00							
Quality Control									

B 10-12-20

10/12/20

8

B 10-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date:	12/15/2010	Req'd Qty: 8.00		Customer:		
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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8012/20		(78)			
130 Packaging Packaging	Identify as per dwg & Stock Location: 128 Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/12/21
MF
10-12-21

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NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 1:39:25 PM

Page 1

Work Order ID: 64335

Parent Item: D4106-5

Parent Item Name: Spacer, Sill Doublber

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	393.5600	0.2109	1.776			



Kydex steel grey



Bp-12-20

Location

therm

111807

Loc Qty

393.56

393.56

Loc Code

111807

8

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NOTE: Date & initial all entries

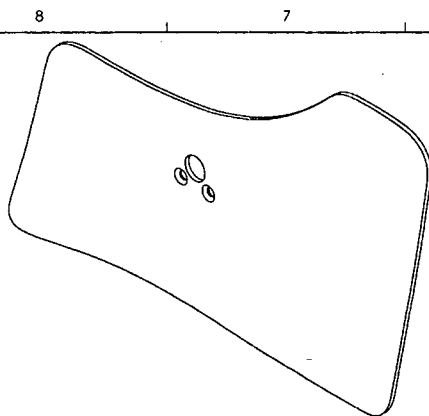
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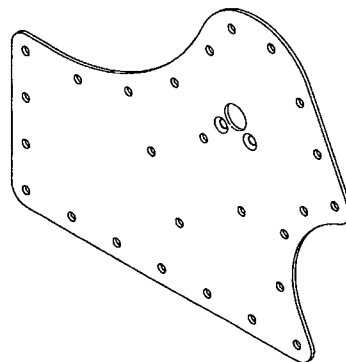
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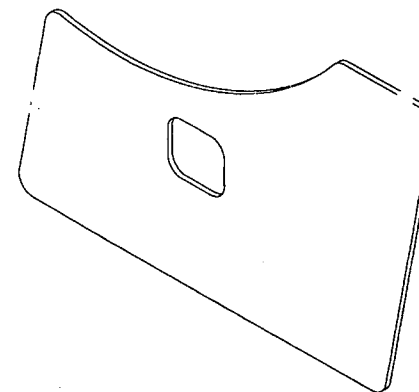
NOTE: Date & initial all entries



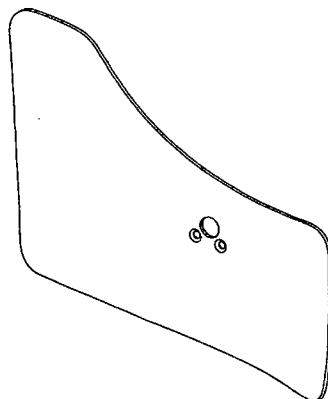
D4106-1 SILL DOUBLER, LH



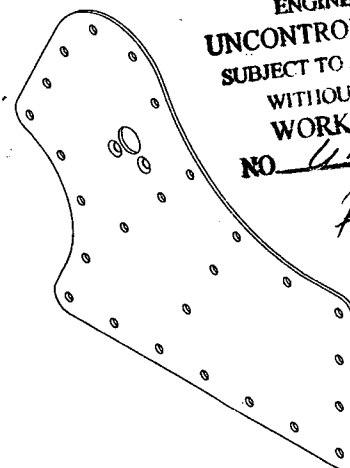
D4106-3 CREW DOOR DOUBLER, LH



D4106-5 SPACER, SILL DOUBLER

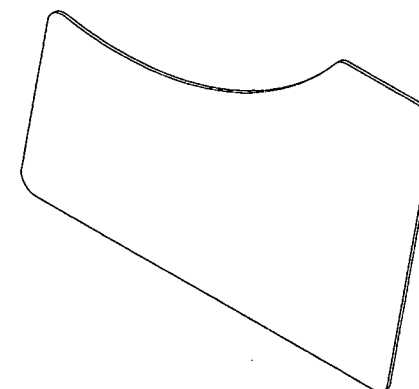


D4106-2 SILL DOUBLER, RH



D4106-4 CREW DOOR DOUBLER, RH

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44335
*Pho 12-3***



D4106-7 TEMPLATE

RELEASED
2010-09-23
JPH

A NEW ISSUE		JPH	10.07.15
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4106 REV. A TITLE DOUBLERS SCALE NTS DATE 10.07.15	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

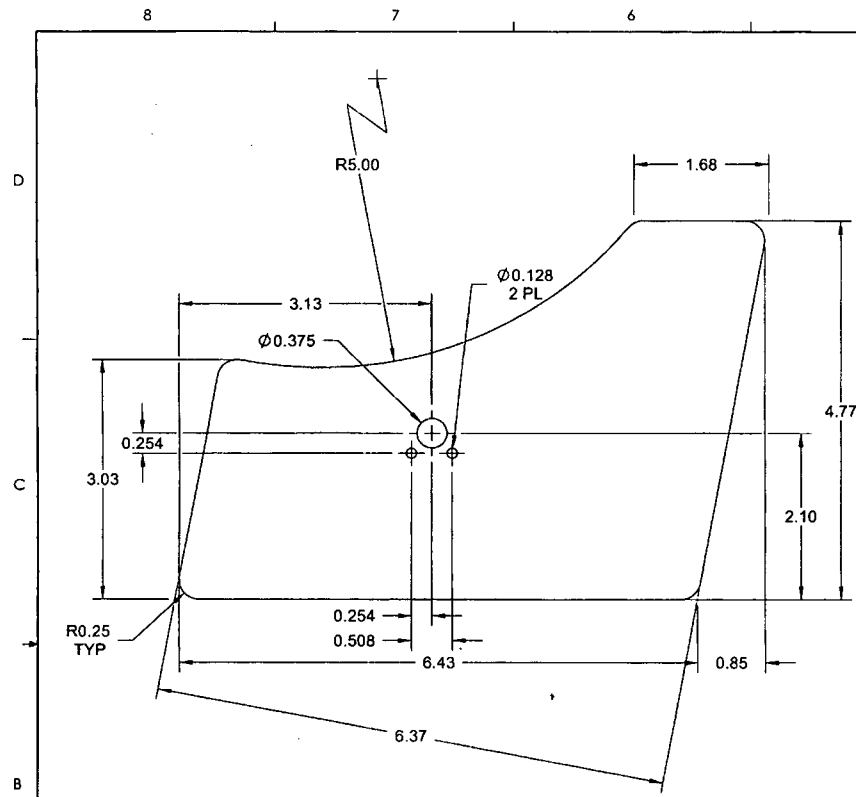
W/O:		WORK ORDER CHANGES					
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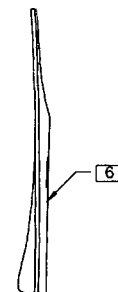
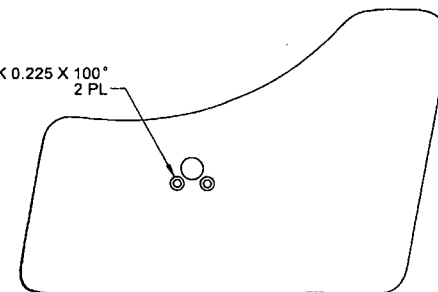
NOTE: Date & initial all entries



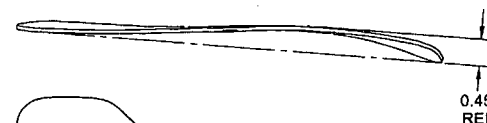
D4106-1F FLAT PATTERN, SILL DOUBLER



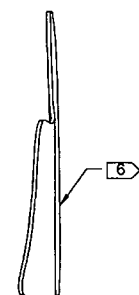
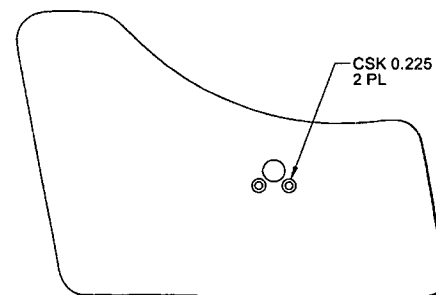
CSK 0.225 X 100°
2 PL



D4106-1 SILL DOUBLER, LH (MAKE FROM D4106-1F)



CSK 0.225 X 100°
2 PL



D4106-2 SILL DOUBLER, RH (MAKE FROM D4106-1F)

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1
DT9647 FOR D4106-2

u/c 64335

RELEASE
2010-09-30

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4106	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
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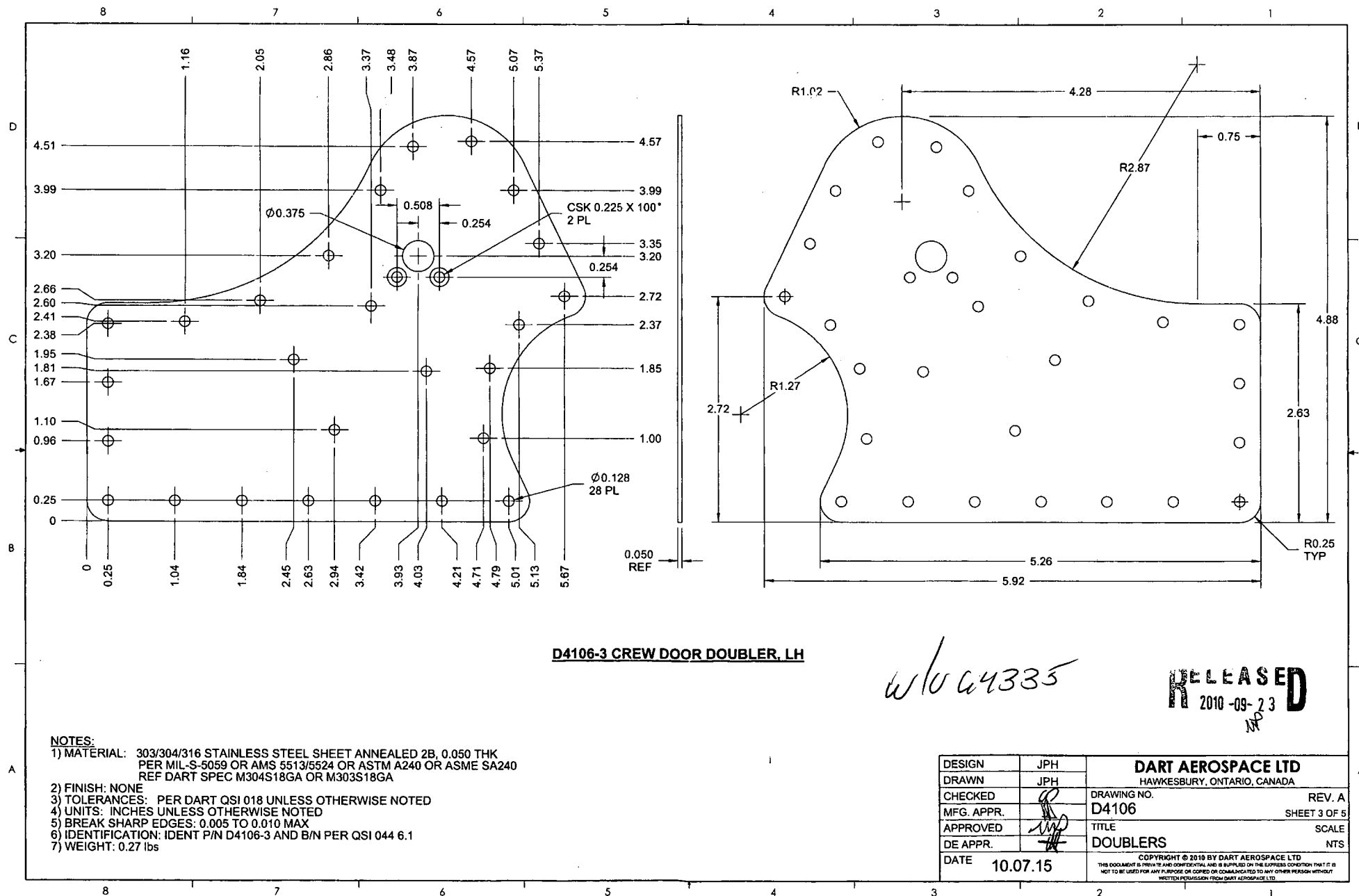
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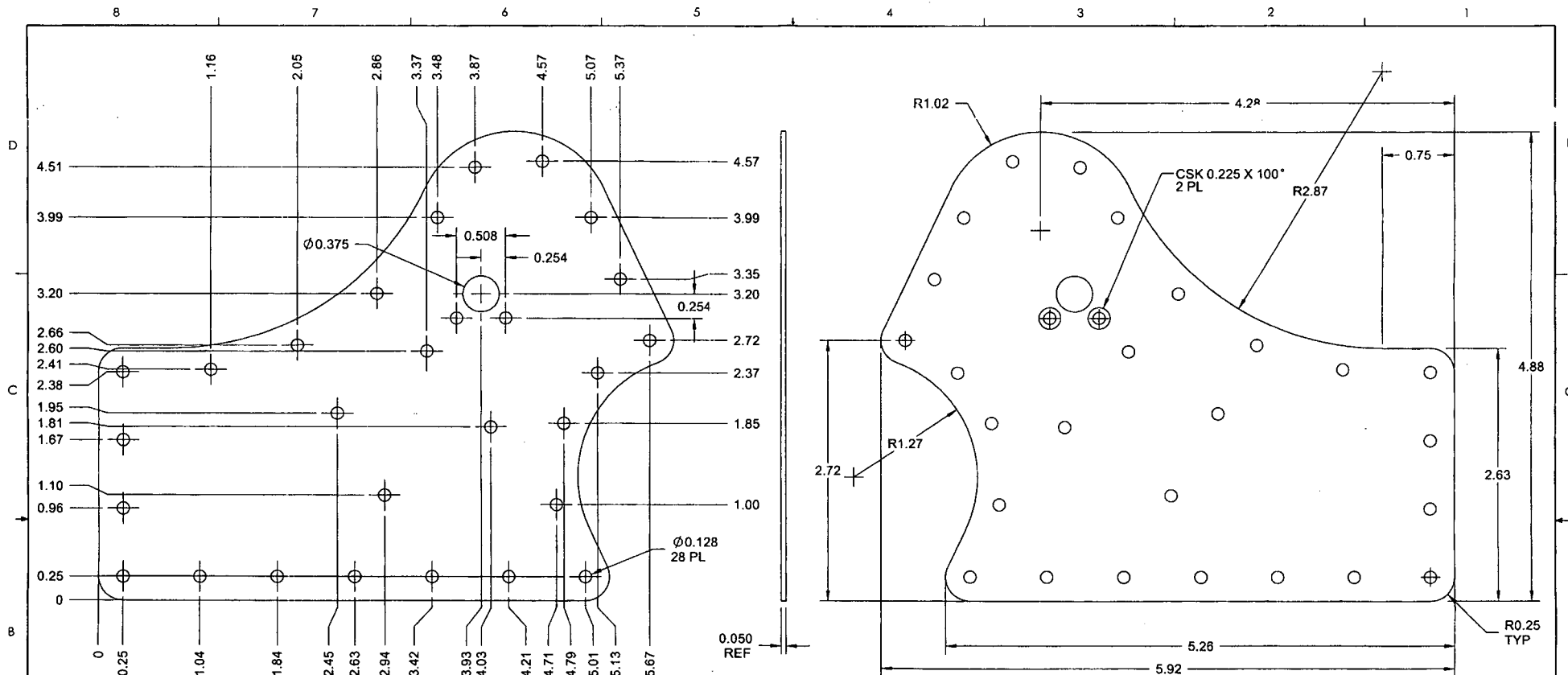
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NOTE: Date & initial all entries



D4106-4 CREW DOOR DOUBLER, RH

W/064335

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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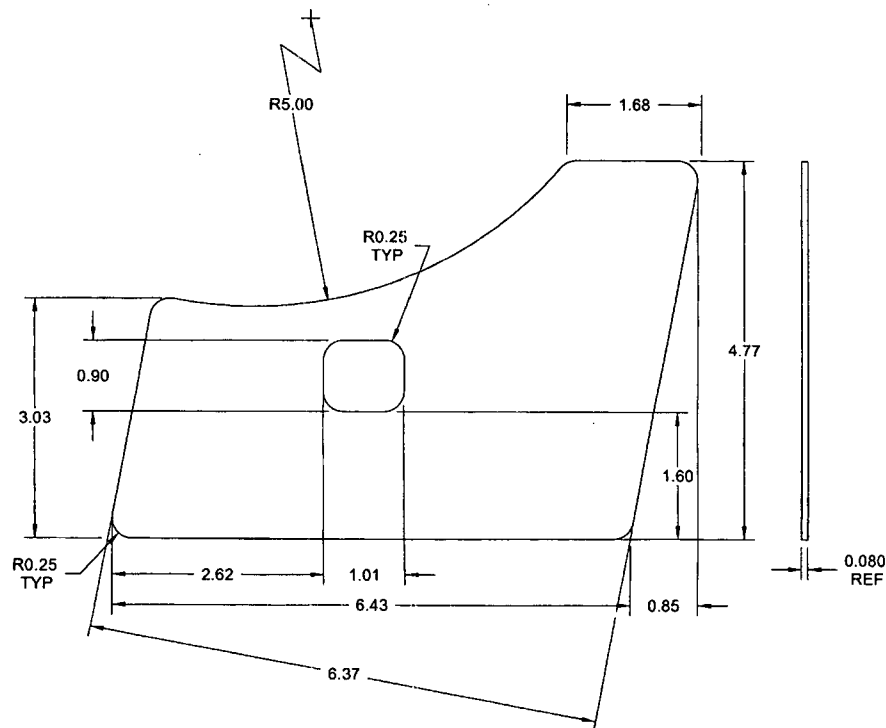
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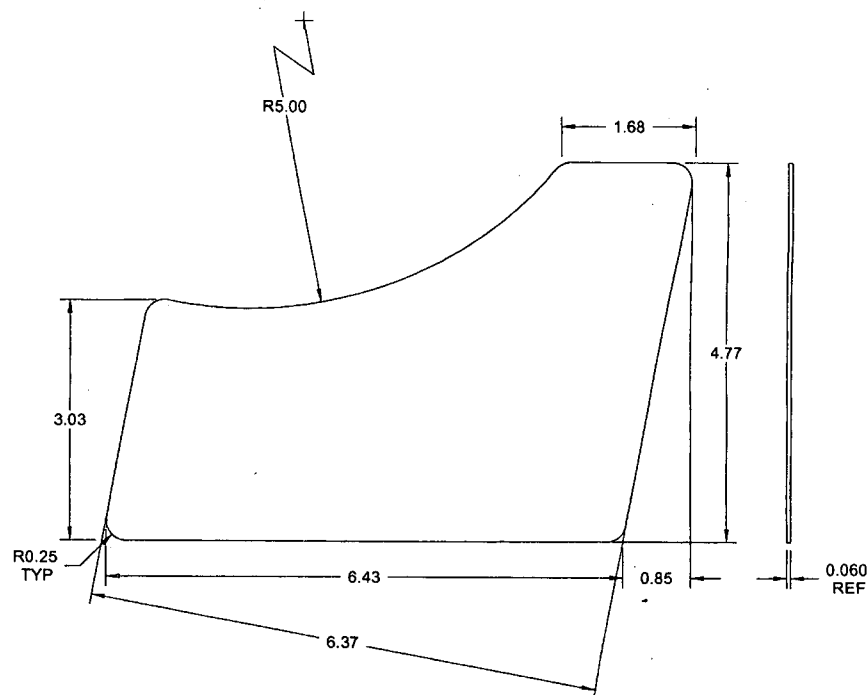
NOTE: Date & initial all entries



D4106-5 SPACER, SILL DOUBLER

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A



D4106-7 TEMPLATE

α/064335

RELEASED
2010-09-23
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